Amendments to the Claims

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

Claim 1 (Currently Amended): A process for shaping and processing pipes, with a plurality of adjustable bending units comprising the following steps:

a) moving the plurality of bending units freely along ~~the pipes~~ at least one pipe; ~~and~~

b) performing a plurality of simultaneous bending operations using the adjustable bending units wherein said plurality of bending units comprises outer bending units which move towards each other longitudinally and inner bending units wherein said inner bending units move apart from each other laterally.

Claim 2 (Canceled).

Claim 3 (Canceled).

Claim 4 (Previously Presented): The process as in claim 1, further comprising the steps of:

providing a plurality of profiled rollers; and

bending a section of the pipe using said plurality of profiled rollers.

Claim 5 (Previously Presented): The process as in claim 4, wherein said step of providing a plurality of profiled rollers includes providing profiled double rollers between a section of the pipe that requires bending.

Claim 6 (Previously Presented): The process as in claim 4, wherein said step of providing a plurality of profiled rollers includes providing at least two outer bending units having gripping pliers.

Claim 7 (Previously Presented): The process as in claim 6, wherein said gripping pliers are profiled.

Claim 8 (Previously Presented): The process as in claim 1, further comprising the step of:

pressing a plurality of sealing nipples axially into two end sections of a piece of pipe shaped material that are being held by said bending units.

Claim 9 (Previously Presented): The process as in claim 8 wherein said step of pressing said sealing nipples into said end sections comprises expanding said end sections by about 45 degrees to create a flange.

Claim 10 (Previously Presented): The process as in claim 1, further comprising the step of heating said pipe to bend said pipe.

Claim 11 (Previously Presented): The process as in claim 10, wherein said heating step is before said bending step.

Claim 12 (Previously Presented): The process as in claim 10, wherein said heating step is during said bending step.

Claim 13 (Previously Presented): The process as in claim 10, wherein said heating step is after said bending step.

Claim 14 (Previously Presented): The process as in claim 10, wherein said heating step includes heating the material into a thermoplastic range.

Claim 15 (Previously Presented): The process as in claim 10, wherein said heating step includes using a radiation heater.

Claim 16 (Previously Presented): The process as in claim 15, wherein said heating step includes using an infrared heater.

Claim 17 (Previously Presented): The process as in claim 10, wherein said heating step includes channeling steam through a pipe section to heat the material.

Claim 18 (Previously Presented): The process as in claim 10, wherein said heating step includes using hot air to heat up a pipe section.

Claim 19 (Previously Presented): The process as in claim 18, wherein said heating step includes pressurizing the hot air in the pipe section.

Claim 20 (Previously Presented): The process as in claim 19, wherein said hot air is left in said pipe section under pressure.

Claim 21 (Previously Presented): The process as in claim 20, further comprising the step of cooling the pipe section after the bending and heating operations have been completed.

Claim 22 (Previously Presented): The process as in claim 20, further comprising the step of forcing cold water through the pipe section for cooling purposes.

Claim 23 (Previously Presented): The process as in claim 1, further comprising the step of pressurizing a pipe section internally during the bending operation.

Claim 24 (Previously Presented): The process as in claim 1, wherein a cross section of a pipe section is stabilized during the bending operation via an insertion of a flexible core.

Claim 25 (Withdrawn): A device for shaping and processing pipes, by performing a plurality of simultaneous bending operations, the device comprising:

a) a plurality of bending units; and

b) at least one carriage assembly for supporting said plurality of bending units, wherein said carriage assembly is mobile and can move along the pipes during the shaping process.

Claim 26 (Withdrawn): The device as in claim 25, further comprising at least two adjacent tracks coupled to said carriage assembly.

Claim 27 (Withdrawn): The device as in claim 25, wherein said bending units further comprise a plurality of bending cores that have different bending raises and different groove sizes.

Claim 28 (Withdrawn): The device as in claim 25, wherein said bending units are designed as robots, wherein said robots are capable of removing a tool that is needed at any time from a magazine.

Claim 29 (Withdrawn): The device as in claim 25, further comprising a control unit, coupled to said bending units said control unit for controlling and setting a plurality of bending parameters for said pipes.

Claim 30 (Withdrawn): The device as in claim 29, wherein said plurality of bending units can be actuated to process a plurality of pipe sections at the same time, and wherein all of said processing units can be actuated to process one single pipe section at least approximately at the same time.

Claim 31 (Withdrawn): The device as in claim 25, further comprising a heating section and a separating unit wherein said at least one carriage assembly is disposed after said separating unit.

Claim 32 (Withdrawn): The device as in claim 31, wherein said at least one carriage assembly is a tandem transport carriage having two supports for the pipe section, and wherein said transport carriage is CNC controlled.

Claim 33 (Withdrawn): The device as in claim 32, wherein said transport carriage further comprises heat insulation facilities, to avoid cooling the heated pipe sections to be transported.

Claim 34 (Withdrawn): The device as in claim 33 wherein said transport carriage can move to at least one take-over position.

Claim 35 (Withdrawn): The device as in claim 34, further comprising gripping tools which are heat insulated, coolable and heatable.

Claim 36 (Withdrawn): The device as in claim 1, further comprising shaping tools configured as transfer units which are

in position to pass each pipe section on to a buffer or transport system once the shaping process has been completed.

Claim 37 (Withdrawn): The apparatus as in claim 36, wherein said processing stations have double bending units.

Claim 38 (Withdrawn): The apparatus as in claim 37, wherein said double bending units are a variable distance away from each other and wherein said two bending units are located so that they can be swivelled in relation to each other.